

Date: Thursday, 2/22/2007 2:56:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 STEP ASSEMBLY
Job Number	: 30807		
Estimate Number	: 11798		
P.O. Number	: N/A	Part Number	: D206628034
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 29740	Material	: N/A
Written By	:	Due Date	: 3/15/2007 Qty: 2 Um: Each
Checked & Approved By	: <u>07.02.23</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-034 CHG 002

KJ 07.03 (2)

2.0	30807A	FLOAT STEP ASSEMBLY LH (206/407)
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Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2842-042 B. 30807A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27313	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-3 Mounting Lug

D29710 ✓

5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm

D11188 ✓

D24/03/27 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:56:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 30807

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm B29785 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2605 f(s)/Unit Total : 2.5211 f(s)

Pick :

Qty Part # Description Batch

2 D2856-400 6.25" Abrasion Strip B29850 ✓

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-041 LUG ASS,Y B29794 ✓

9.0

AN4C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN4C12A Bolt M103481 (15x) ✓ M103691 (K) ✓

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3C4A Bolt M103691 ✓

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C15A Bolt M10291 ✓

[Signature]
04/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:56:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 30807

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 6.0000 EACH(s)

Pick:

Qty Part Number Description Batch

3 AN960C10 WASHER

M101064 ✓

13.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960JD416L Washer

M101237 (47) ✓ M3154 1X ✓ 2/24/4

14.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

M103338 ✓ M3154 1X ✓

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4 Nut (or MS21042-4)

M102959 ✓

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

M100993 ✓ 2/24/11 (2)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2/24/11 (2)
C267104111 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:56:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 30807

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-034

Location: _____

PPP Rev: _____

2/24/11 (2)

19.0

QC21

FINAL INSPECTION W/O RELEASE



(2)

Comment: FINAL INSPECTION W/O RELEASE

2/27/04/12

Job Completion



U 87-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/09/2007 1:11:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628
Job Number	: 34468		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 07/09/2007 S.O. No. : N/A	Drawing Number	: ECN 1029
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: <u> </u>	Due Date	: 14/09/2007
Checked & Approved By	: <u> </u>	Qty:	1 Um: Each
Comment	: <u> </u>		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029

EASA STC: EASA.IM.R.S.01339 :

D206-628-011

33411 (3X)

33038 (4X)

32979 (1X)

D206-628-012

32980 (1X)

33892 (1X)

D206-628-013

D206-628-014

18533 (1X) 18943 (1X)

D206-628-021

31976 (3X)

33756 (3X)

29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X)

31011 (4X)

D206-628-033

30806 (2X)

31241 (2X)

D206-628-034

30807 (2X)

7/8/11 SP

Date: Friday, 07/09/2007 1:11:06 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-628

Job Number: 34468

Part Number: Z_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

RETURN FG'S TO-STK

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/11

Job Completion



u 07-29-11

Date: Tuesday, 05/02/2008 3:14:05 PM
User: Dominique Dube

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628-034
Job Number	: 37233	Part Number	: D206628034
Estimate Number	: 10804	Drawing Number	: ECN 1118
P.O. Number	:	Project Number	:
This Issue	: 05/02/2008 S.O. No. :	Drawing Revision	:
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 12/02/2008 Qty: 1 Um: Each
Previous Run	: 37232		
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

1+ 30807 003

D206-628-034 CHG002 1x B33924 ✓

33924

✓

①

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118

*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER ***

8x D2732 RUBBER EXTRUSION

CUT 3.00" LONG B

34717

B34717 D2 (✓)

8x AN4C14A BOLT B

107087

M107087 (✓)

8/2/12

50

①

3.0	D2732	Rubber Extrusion
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Comment: Qty.: 8.0000 f(s)/Unit Total: 8.0000 f(s)
Rubber Extrusion

1534717

4.0	AN4C14A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bolt

M107087

8/2/12

50

①

Date: Tuesday, 05/02/2008 3:14:05 PM
User: Dominique Dube

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-628-034

Job Number: 37233

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2008.26 (X1)

5 08/02/12 (K)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*** PLEASE ADD A COPY OF THIS WORK ORDER
TO THE ABOVE WORK ORDERS ***

①
AD 08/02/26

Job Completion



2008/2/19 *①*